

Work Order ID 58980

May 20, 2010 1:38:24 PM



Page 1

Item ID: D4064-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Lug

Start Date: 5/20/10 Start Qty: 20.00



Cust Item ID:



Required Date: 5/28/10 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan: U

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4064

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per Dwg

DWG REV: A

PROG REV: A

DEBURR IF REQUIRED

IB 10-5-26

0

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

IB 10-5-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58980

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May 20, 2010 1:38:25 PM

Item ID: D4064-041

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Item Name: Mounting Lug

Start Date: 5/20/10 Start Qty: 20.00



Cust Item ID:

Required Date: 5/28/10 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Mill Conv Conventional Milling Machine	Memo MILL RADS, DRILL HOLES AS PER DWG GRIND RAD .060"-.100" BY HAND	0.00 0.00				20	0		
140 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				20			
150 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				20			



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58980

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Item ID: D4064-041

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Cust Item ID:

Required Date: 5/28/10 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00

ml 10/06/09

20 0



HandFinish

Memo

0.00

Hand Finishing

170

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

= ml 10/06/09

20 0



Powdercoat

Memo

0.00

Powder Coating

M114841

START: 10:15am

Temp: 320°F

FIN: 10:45am

180

QC3- Inspect Part Finish

0.00

ml 10 08 09 (20)



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58980

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Setup Start



Revision ID:

Stop



Item Name: Mounting Lug

Start Date: 5/20/10 Start Qty: 20.00



Cust Item ID:

Required Date: 5/28/10 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

190

0.00



HandFinish

Memo

0.00

Hand Finishing

ASSEMBLE GROMMETS AS PER DWG

Handwritten: 4510/06/08 (20)

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Handwritten: Solo 6/07

Handwritten: 420

210

Identify as per dwg & Stock Location: *464*

0.00



Packaging

Memo

0.00

Packaging

Handwritten: 20 BB 10/06/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 58980

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Item ID: D4064-041

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Item Name: Mounting Lug

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Cust Item ID:

Required Date: 5/28/10 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/10

R10-6-09
20

POSITIVE RECALL
EFFECTIVE _____
RELEASED _____
AUTH _____
DATE _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May 20, 2010 1:38:23 PM

Page 1

Work Order ID: 58980

Parent Item: D4064-041

Parent Item Name: Mounting Lug

Comments: IPP REV:A NEW ISSUE 10-03-01 JLM VERIFIED BY:EC

Start Date: 5/20/10

Required Date: 5/28/10

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

M6061T6B0.750X06.00
0

Purchased

No

100

f

53.0800

0.35

7.



6061T6 BAR .750 X 6.00



1810-5-26

Location

Loc Qty

Loc Code

MAT03

53.08

112567

53.08

MS35489-93

Purchased

No

190

Each

123.0000

2



GROMMET



112867

5/20/06/09

Location

Loc Qty

Loc Code

ST293

100

114341

100

ST295

23

114108

23

17

23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

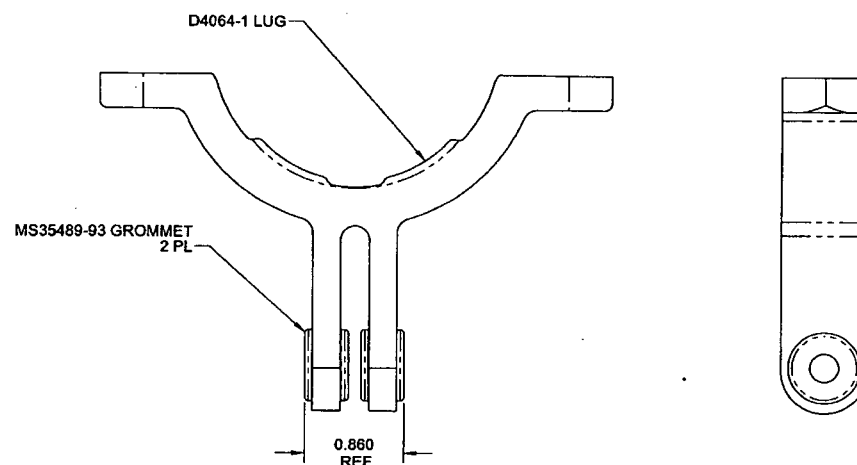
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

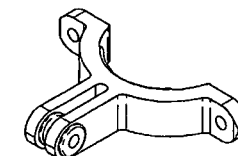
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4064-041	LUG ASSEMBLY
2	1	D4064-1	LUG
3	2	MS35489-93	GROMMET



D4064-041 LUG



RELEASED
2010-03-01

NOTES:

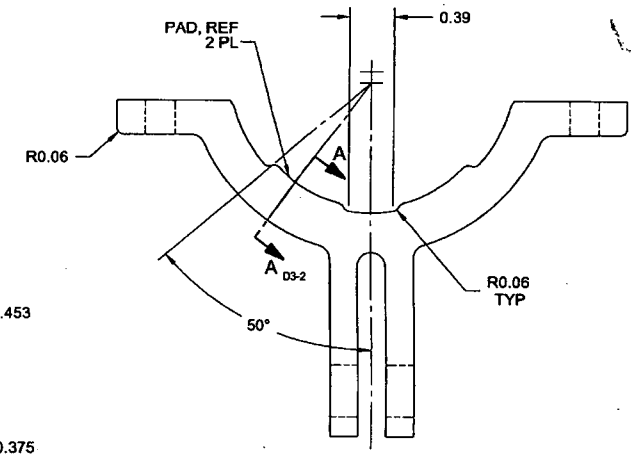
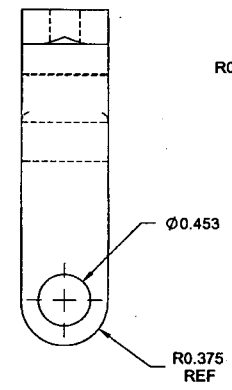
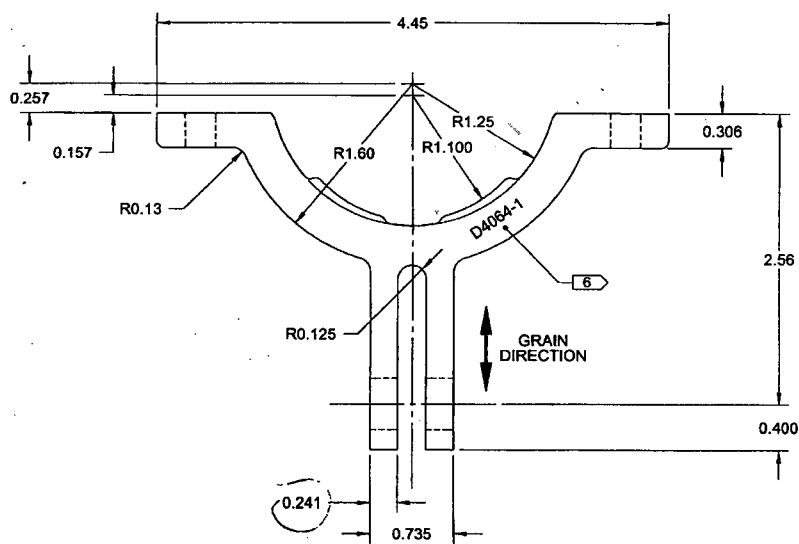
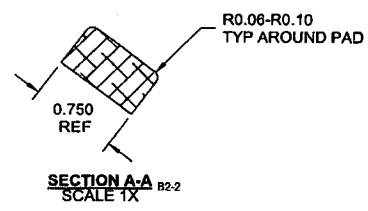
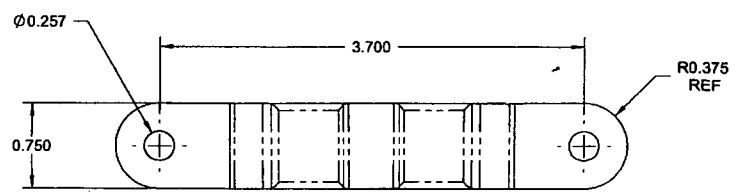
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.18 lbs

A	NEW ISSUE	CP	10.01.25
REV.	DESCRIPTION	BY	DATE
DESIGN	g1		
DRAWN	g1		
CHECKED	g1		
MFG. APPR.	g1		
APPROVED	g1		
DE APPR.	g1		
DATE	10.01.25		

DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWING NO. D4064	REV. A
TITLE CLAMP	SHEET 1 OF 2
	SCALE NTS

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8 7 6 5 4 3 2 1



D4064-1 LUG

RELEASE
2010-03-01

- NOTES:**
- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, BAR, OR EXTRUSION
PER QQ-A-200/8, QQ-A-225/8, QQ-A-250/8, ASTM B209, ASTM B211, OR ASTM B221
(REF DART SPEC. M6061T6B, M6081T6S)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ENGRAVE PART NUMBER TO DEPTH OF 0.010±0.005 IN THIS LOCATION,
WITH TOOL A TIP RADIUS OF 0.015±0.005
 - 7) WEIGHT: 0.18 lbs

Mo 5800

DESIGN	98	DART AEROSPACE LTD	
DRAWN	98	HAWKESBURY, ONTARIO, CANADA	
CHECKED	h	DRAWING NO.	REV. A
MFG. APPR.	E	D4064	SHEET 2 OF 2
APPROVED	#	TITLE	SCALE
DE APPR.	#	CLAMP	NTS
DATE	10.01.25	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1